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**UTILITY
PATENT APPLICATION
TRANSMITTAL**

(Only for new nonprovisional applications under 37 CFR 1.53(b))

APPLICATION ELEMENTS

See MPEP chapter 600 concerning utility patent application contents.

- Fee Transmitted Form (e.g., PTO/SB/17)**
(Should be signed and a duplicate for fee processing)
- Applicant claims small entity status.
See 37 CFR 1.27.
- Specification [Total Pages 18]
(preferred arrangement set forth below)
 - Descriptive title of the invention
 - Cross Reference to Related Applications
 - Statement Regarding Fed Sponsored R & D
 - Reference to sequence listing, a table, or a computer program listing appendix
 - Background of the Invention
 - Brief Summary of the Invention
 - Brief Description of the Drawings (if filed)
 - Detailed Description
 - Claim(s)
 - Abstract of the Disclosure
- Drawing(s) (35 U.S.C. 113) [Total Sheets 1]
- Oath or Declaration [Total Pages 2]
 - Newly executed (original or copy)
 - Copy from a prior application (37 CFR 1.63 (d)) (for continuation/divisional with Box 17 completed)
 - DELETION OF INVENTOR(S)**
Signed statement attached deleting inventor(s) named in the prior application, see 37 CFR 1.63(d)(2) and 1.13(b).
- Application Data Sheet. See 37 CFR 1.76

17. If a CONTINUATING APPLICATION, check appropriate box, and supply the requisite information below and in a preliminary amendment, or in an Application Data Sheet under 37 CFR 1.76:

 Continuation Divisional Continuation-in-part (CIP)

of prior application No. _____ / _____

Group 1 Art Unit: _____

For CONTINUATION OR DIVISIONAL APPS only: The entire disclosure of the prior application, from which an oath or declaration is supplied under Box 5b, is considered a part of the disclosure of the accompanying continuation or divisional application and is hereby incorporated by reference. The incorporation can only be relied upon when a portion has been inadvertently omitted from the submitted application parts.

18. CORRESPONDENCE ADDRESS

<input type="checkbox"/> Customer Number or Bar Code Label	<input type="checkbox"/> <i>Please print Customer No. or attach Bar code label here</i>			<input type="checkbox"/> Correspondence address below
Name	Huntley & Associates			
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Signature	<i>Donald W. Huntley</i>		
Date 10/6/00			

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FEE TRANSMITTAL

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TOTAL AMOUNT OF PAYMENT (\$ 1,202.00)

METHOD OF PAYMENT1. The Commissioner is hereby authorized to charge indicated fees and credit any overpayments to:

Deposit Account Number **08-3440**
 Deposit Account Name **Huntley & Associates**

Charge Any Additional Fee Required
 Under 37 CFR 1.16 and 1.17

Applicant claims small entity status.
 See 37 CFR 1.27

2. Payment Enclosed:

Check Credit card Money Order Other

FEES CALCULATION**1. BASIC FILING FEE**

Large Entity Small Entity

Fee Code (\$)	Fee Code (\$)	Fee Description	Fee Paid
101	710	201 355 Utility filing fee	710
102	320	206 160 Design filing fee	
107	490	207 245 Plant filing fee	
108	710	208 355 Reissue filing fee	
114	150	214 75 Provisional filing fee	
SUBTOTAL (1) (\$ 710)			

2. EXTRA CLAIM FEES

Total Claims	Extra Claims	Fee from below	Fee Paid
34	-20** = 14	X 10	125
Independent Claims	6	-3** = 3	X 80 240
Multiple Dependent			

Large Entity Small Entity

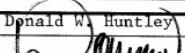
Fee Code (\$)	Fee Code (\$)	Fee Description	Fee Paid
103	18	203 9 Claims in excess of 20	
102	80	202 40 Independent claims in excess of 3	
104	270	204 135 Multiple dependent claim, if not paid	
109	80	209 40 ** Reissue independent claims over original patent	
110	18	210 9 ** Reissue claims in excess of 20 and over original patent	
SUBTOTAL (2) (\$ 492)			

**or number previously paid, if greater; For Reissues, see above

Complete If Known			
Application Number			
Filing Date	October 6, 2000		
First Named Inventor	Jeffrey W. Stone		
Examiner Name			
Group Art Unit			
Attorney Docket No.	RA-0336		

FEES CALCULATION (continued)**3. ADDITIONAL FEES**

Large Entity	Small Entity	Fee Description	Fee Paid
105	130	205 65 Surcharge - late filing fee or oath	
127	50	227 25 Surcharge - late provisional filing fee or cover sheet	
139	130	139 130 Non-English specification	
147	2,520	147 2,520 For filing a request for ex parte reexamination	
112	920*	112 920 Requesting publication of SIR prior to Examiner action	
113	1,840*	113 1,840* Requesting publication of SIR after Examiner action	
115	110	215 55 Extension for reply within first month	
116	390	216 195 Extension for reply within second month	
117	890	217 445 Extension for reply within third month	
118	1,390	218 695 Extension for reply within fourth month	
128	1,890	228 945 Extension for reply within fifth month	
119	310	219 155 Notice of Appeal	
120	310	220 155 Filing a brief in support of an appeal	
121	270	221 135 Request for oral hearing	
138	1,510	138 1,510 Petition to institute a public use proceeding	
140	110	240 55 Petition to revive - unavoidable	
141	1,240	241 620 Petition to revive - unintentional	
142	1,240	242 620 Utility issue fee (or reissue)	
143	440	243 220 Design issue fee	
144	600	244 300 Plant issue fee	
122	130	122 130 Petitions to the Commissioner	
123	50	123 50 Petitions related to provisional applications	
126	240	126 240 Submission of Information Disclosure Stmt	
581	40	581 40 Recording each patent assignment per property (times number of properties)	
146	710	246 355 Filing a submission after final rejection (37 CFR § 1.129(a))	
149	710	249 355 For each additional invention to be examined (37 CFR § 1.129(b))	
179	710	279 355 Request for Continued Examination (RCE)	
169	900	169 900 Request for expedited examination of a design application	
Other fee (specify)			
Reduced by Basic Filing Fee Paid			SUBTOTAL (3) (\$ 0)

SUBMITTED BY		Complete (if applicable)	
Name (Print/Type)	Donald W. Huntley	Registration No.	24,673
Signature		Attorney/Agent	
Date	October 6, 2000		

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LEAD FREE POWDERED METAL PROJECTILES

CROSS-REFERENCE TO RELATED APPLICATION

This is a Continuation-in-Part of copending application Serial Number 09/226,252 filed January 7, 1999, which is a Continuation of application Serial Number 08/908,880 filed August 8, 1997, now U.S. Patent 5,917,143.

BACKGROUND OF THE INVENTION

This invention relates to lead free projectiles. Specifically, this invention relates to lead free projectiles that are significantly less dense than previous lead containing projectiles. More specifically, this invention relates to lead free projectiles that are significantly less dense than previous lead free projectiles, which were designed to approximate the theoretical density of lead.

Because lead is a potential source of environmental problems and health concerns, there is a need for lead free projectiles and ammunition, as well as a method of manufacturing such lead free projectiles and ammunition. Frangible lead free projectiles are useful in indoor shooting ranges, and reduce any potential problems resulting from airborne lead dust, as well as reducing costly environmental cleanup. Non frangible lead free projectiles are useful in hunting and other outdoor activities, especially when such activities occur in environmentally sensitive areas.

Previous lead free projectiles were conceived, designed, configured and manufactured to simulate, as accurately as possible, the theoretical density of lead. Such simulation was previously thought to be desirable so that a shooter would not perceive a great difference between the feel of shooting a projectile containing lead and one that is lead free. For example, in U.S. Patent 5,760,331, Lowden et al. disclose a lead free projectile designed to closely approximate the density of lead by incorporating a denser than lead component and a less dense than lead component.

One solution to the need for lead free projectiles has been the use of a compacted, unsintered admixture of metal particles comprising tungsten and at least one other metal selected from the group of iron and copper. However, the admixture process and the use of tungsten adds to the cost of manufacturing such projectiles.

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SUMMARY OF THE INVENTION

The present invention provides lead free projectiles that are not limited by the theoretical density of lead, and thus offers more flexibility in terms of materials used and methods of manufacture. The projectiles of the present invention satisfy the need for lead free projectiles without the expense of high cost materials and processing. The projectiles of the present invention produce a similar "feel" and mimic the ballistic properties of lead projectiles of similar caliber and size, as well as similar lead free projectiles. Specifically, the present invention provides an alternative to lead that is less dense than lead but still retains similar external ballistic properties. In preferred embodiments, the projectiles of the present invention exhibit external ballistic properties similar to previous lead containing and lead free projectiles, especially when fired within ranges of about 100 yards or less.

Specifically, the present invention provides a lead free projectile comprising a compacted admixture of a high ductility metal powder and a low ductility metal powder, wherein the low ductility metal powder is less dense than lead and the projectile is less dense than lead. Alternatively, the present invention provides a lead free projectile having a density less than the theoretical density of lead. The present invention also provides a lead free projectile comprising a compacted admixture of iron powder and at least one powder selected from tin, zinc and alloys and mixtures thereof.

20

DETAILED DESCRIPTION OF THE INVENTION

The projectiles of the present invention, and the processes for manufacturing them, will be more fully understood by reference to the following description. When used herein, projectile includes bullet, shot, and other projectiles associated with firearms. Projectile as used herein include core, which is formed from the compacted metal powders, as well as the jacketed or unjacketed core that can be loaded into a cartridge to form a round of ammunition. Variations and modifications of both the projectiles and the processes can be substituted without departing from the principles of the invention, as will be evident to those skilled in the art.

30 The projectiles of the present invention comprise a mixture of metal powders, and can comprise lubricants and other materials that aid in the manufacture of such projectiles. The metal powder is a mixture of at least one high ductility metal powder and at least one

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low ductility metal powder. The high ductility metal powder facilitates cold forming and ease of manufacture of the powder metal mixture into a finished projectile shape by conventional projectile forming technology. The low ductility metal powder reduces the overall cost of the powder metal mixture by acting as a filler that does not sacrifice the material properties of the low ductility metal.

The high ductility metal powder can be a single metal or a mixture of metal powders having high ductility. High ductility as used herein means that the stress-strain characteristic of the material will have an almost indistinguishable transition between elastic and inelastic response regions. Examples of high ductility metal powders that can be used

according to the present invention include tin, zinc, copper, aluminum, brass, and to a lesser extent gold and platinum. To the extent that any material used is more dense than lead, the low ductility metal should be less dense than lead. Of the above high ductility metals that can be used, tin and zinc are particularly preferred. The selection of a particular high ductility metal powder or mixture of powders will depend on a variety of factors, including the particular low ductility metal material used, and the ratio of low ductility to high ductility metal powder used in fabricating the projectile. In addition, where the high ductility metal powder comprises a mixture of metal powders, metals with lower ductility may be used in combination with the preferred high ductility metals to form a compact having high ductility.

The density of the high ductility metal powder is preferably less than the theoretical density of lead, however, the density of the high ductility metal powder can be greater than lead if the density of the projectile is less than lead. In addition, if the high ductility metal powder consists of a mixture of powders, the mixture can contain metals of varying density. Again, it is preferred that the density of such mixtures be less than the theoretical density of lead, but the density of the mixture can be greater than lead so long as the composite density of the projectile is less than the theoretical density of lead.

The low ductility metal powder can be a single metal or a mixture of metal powders having low ductility. Low ductility as used herein means that the material will have a well defined transition between elastic and inelastic response regions in the stress-strain characteristic relationship of the material. Examples of low ductility metal powders that can be used according to the present invention include iron, steel, stainless steel and nickel. Of these, iron is particularly preferred. The selection of a particular low ductility metal

powder or mixture of powders will depend on a variety of factors, including the particular high ductility metal material used, and the ratio of low ductility to high ductility metal powder used in fabricating the projectile. In addition, where the low ductility metal powder comprises a mixture of metal powders, metals with higher ductility can be used in combination with the preferred low ductility metals to form a mixture having low ductility.

The density of the low ductility metal powder is preferably less than the theoretical density of lead, however, the density of the low ductility metal powder can be greater than lead if the composite density of the projectile is less than lead. In addition, if the low ductility metal powder consists of a mixture of powders, the mixture can contain metals of varying density. Again, it is preferred that the density of such mixtures be less than the theoretical density of lead, but the density of the mixture can be greater than lead so long as the density of the projectile is less than lead.

Regardless of the densities of each of the high and low ductility metal powders, the density of the projectile formed from the powders is preferably less than the theoretical density of lead.

To obtain a projectile of the present invention, it is preferred that the projectile comprise about two parts by volume of high ductility metal powder to one part low ductility metal powder. The preferred ratio ensures that the compacted metal powder mixture will take on properties, including properties such as ductility and formability that aid in the production of projectiles of the present invention, of the powder metal more highly represented in the mixture. The preferred material properties are those of the higher ductility metal powder, and thus it is preferred that the higher ductility metal powder comprise a higher percentage of the mixture.

The projectiles of the present invention can be manufactured by a wide variety of methods. Typically, the projectiles are made by compacting the mixture of metal powders, and then finishing the projectile, if necessary, by sintering, swaging, or otherwise modifying the compacted mixture. Other finishing steps can include jacketing the compacted mixture. Jacketing can be accomplished by a wide variety of known methods. Compacting can be carried out at substantially ambient conditions, without applied heat, or under heated conditions. The method of manufacture will vary depending on a wide variety of parameters, including the desired projectile, the specific composition of the metal powders,

the particle size of the metal powders, and other factors that will be obvious to one skilled in the art.

When compacting a mixture of metal powders, it is preferred that the low ductility powder have a pre-compaction particle size distribution of about from 44 to 250 μm . More

5 specifically, a preferred low ductility mixture can have a particle distribution of about 15 to 25% by weight of particles up to about 44 μm , about from 5 to 70% by weight of particles having a particle size of about from 44 to 149 μm , and about from 5 to 15% by weight of particles having a particle size of about from 149 to 250 μm . Even more advantageous is a
10 pre-compaction particle size distribution of about 22% by weight of particles up to about 44 μm , about 68% by weight of particles having a particle size of about from 44 to 149 μm , and about 10% by weight of particles having a particle size of about from 149 to 250 μm . The desired particle size distribution can be determined and obtained through a variety
15 of conventional methods, including optical measurements and sifting. The particles are also available commercially in specific particle size distributions. A preferred high ductility material comprises powder having a pre-compaction particle size distribution of about from 45 to 180 μm . More specifically, a preferred high ductility mixture can have a particle distribution of about 10-14% by weight of particles up to about 45 μm , about from 30-50% by weight of particles having a particle size of about 75 μm , about from 20-30% by weight of particles having a particle size of about 106 μm , about from 5-10% by weight of particles having a particle size of about 150 μm , and about from 2-4% by weight of particles having a particle size of about 180 μm . Even more advantageous is a pre-compaction particle size distribution for the low ductility metal of about 14% by weight of particles of about 45 μm , about 48% by weight of particles having a particle size of about 75 μm , about 28% by weight of particles having a particle size of about 105 μm , about 7% by weight of particles having a particle size of about 150 μm , and about 3% by weight of particles having a particle size of about 180 μm .

Some embodiments of the projectile of the present invention may be frangible. Frangible as used herein, consistent with its use in the firearms and ammunition industry, means that the projectile breaks apart completely upon striking a hard target. Frangible lead free projectiles of the present invention can be prepared by a process of manufacture involving only the cold compacting of the high and low ductility metal powders. Non

frangible projectiles can be made by cold compacting the metal powders, and can also be made by heat treating the cold compacted metal powders to strengthen the bond between the powders. Frangibility depends, at least in part, on the particle size distribution of the high and low ductility metals used. It has been found to be particularly advantageous to

5 have a pre-compaction particle size distribution of about from 15 to 25% by weight of particles up to about 44 μm , about from 5 to 70% by weight of particles having a particle size of about from 44 to 149 μm , and about from 5 to 15% by weight of particles having a particle size of about from 149 to 250 μm . Even more advantageous is a pre-compaction particle size distribution of about 22% by weight of particles up to about 44 μm , about
10 68% by weight of particles having a particle size of about from 44 to 149 μm , and about 10% by weight of particles having a particle size of about from 149 to 250 μm . The desired particle size distribution can be obtained through a variety of conventional methods, including optical measurements and sifting. The particles are also available commercially in specific particle size distributions.

15 Many other particle sizes and particle size distributions can be used to fabricate a projectile of the present invention, including non frangible projectiles. Typically, the particle size of each of the powders can vary, depending on a variety of factors such as the ratio of metal powders, and the ratio of the particle sizes of the metal powders. In addition to the wide variety of particle sizes that can be used, it is preferred that the particles be of
20 irregular shape to promote bonding and strength. It has been found that irregularly shaped particles, when used according to the present invention and when used as components in projectiles of the present invention, improve the bonding of the metal powders and contribute to the green strength of the compacted projectiles, as compared to spherical or regularly shaped particles.

25 The particle size distributions described above have been found to provide the advantage of integrity of the projectile before and during firing and frangibility upon impact with a target media. While the relationship between particle size distribution and frangibility are not fully understood, it is believed to be a function of the mechanical interlocking of the particles after the cold compaction of the high and low ductility metal
30 powders. In addition, the preferred particle size distribution has been found to provide strength to the compacted composite projectiles of the present invention, and is thought to be one factor enabling the formation of unsintered projectiles of the present invention. By

providing such increased robustness and strength, the preferred particle size distribution may provide one factor allowing simplified fabrication of the projectiles of the present invention, involving merely the cold compacting of the metal powders.

The projectiles of the present invention can be manufactured by a process wherein
5 the high and low ductility metal powders of the desired particle sizes are admixed to provide a mixture with the desired ratio of metal powders and if desired, with a desired particle size distribution. The high and low ductility metal powders can also preferably be mixed with one or more lubricants or a mixture of lubricants. A lubricant aids in removing the projectiles from the mold after compaction is complete. If a lubricant is to be added, it
10 can be added to either metal powder or the mixture of metal powders. A preferred lubricant is zinc stearate, which can be used alone or in combination with other lubricants. Up to about 1.0% by weight of zinc stearate can be beneficially added to the mixture of high and low ductility metal powders prior to compaction. About 0.5% has been found to be particularly satisfactory.

15 The admixture is then placed in a die which is designed to provide the desired shape of the projectile. A wide variety of projectiles can be made according to the present invention, including shot and bullets. The invention is particularly beneficial in bullet manufacture, and especially those having a generally elongated configuration in which a leading end has a smaller circumference than a trailing end.

20 For both frangible and non frangible projectiles according to the present invention, the mixture of high and low ductility metal powders is cold compacted at a pressure of about from 50,000 to 120,000 psi, with a pressure of about 100,000 psi being particularly preferred. Compacting at a pressure of about 100,000 psi provides the optimal combination of projectile integrity before and during firing and frangibility upon impact
25 with a target. The compaction step can be performed on any mechanical press capable of providing at least about 50,000 psi pressure for a dwell time which can be infinitesimally small. Presently available machinery operates with dwell times of about from 0.05 to 1.5 seconds. Preferably, a conventional rotary dial press is used. A compaction ratio of about 1.8 to 2.3 is preferred. Compaction ratio is used herein in the common sense, meaning that
30 the initial volume of power is compared to the volume of the compacted composite that can form a projectile of the present invention. For non-frangible projectiles, the process may be

varied in terms of compaction time or pressure, or the process could further comprise heat treatment such as sintering.

After the projectile is formed by cold compaction, a jacket can be formed around the projectile if so desired. Some embodiments of the projectiles of the present invention do not require jackets. The need to incorporate a jacket into the projectiles of the present invention will depend upon the specific mixture and composition of the metal powders used to fabricate the projectile. In other embodiments, a jacket may be preferred for a variety of reasons. For example, the jacket can isolate the powdered iron material of the projectile from a gun barrel, preventing erosion of the rifling of the gun barrel which might result from direct contact between the interior surface of the barrel and the powdered iron of the projectile. The jacket also helps provide additional integrity of the projectile before and during firing as well as improving the ballistics of the projectile upon firing. The jacket material can be selected from those customarily used in the art, for example, metal or polymeric material. Metals which can be used include aluminum, copper, zinc and combinations thereof, with copper or brass being a preferred choice. Polymeric materials which can be used include polyethylene and polycarbonate, with a low density polyethylene material being preferred.

In the case of metal jackets, the jacket can be applied by any number of conventional processes, including acid or cyanide electroplating, mechanical swaging, spray coating, and chemical adhesives. The preferred method is electroplating.

A variety of electroplating techniques can be used in the instant invention, as will be evident to those in the plating art. In general, the projectiles are cleaned and sealed before the final plating. The sealing can be with impregnating methacrylate and polyester solutions.

In a preferred method of plating, a vacuum impregnation is performed immediately after compaction and prior to electroplating. This impregnation involves infusion of the formed projectile cores in methacrylate material in a large batch type operation. The impregnation step reduces the porosity of the projectiles by filling voids at or near the surface of the projectiles. These voids can contain impurities which might cause corrosion and plate fouling. The impregnation step also provides a barrier to prevent collection of plate bath chemicals in the recesses. Such collected chemicals could leach through the plating, discoloring and changing the dimensions of the bullet.

After sealing the surface of the projectiles, they can be plated with jacketing material to deposit the desired thickness of plating metal on the projectiles. Acid copper plating is preferably used, which is faster and more environmentally friendly than alternative techniques, such as cyanide copper plating. After jacketing, the projectiles can be sized 5 using customary techniques and fabricated into cartridges.

In addition to the protective benefits obtained by adding a jacket to the projectiles of the present invention, the additional mass of the jacket aids in the functionality and reliability of the projectiles when used with semi-automatic and fully automatic firearms. Such firearms require that a minimal impulse be delivered to the gun slide for operation, 10 and the mass added by a jacket (approximately 5-10% increase) can provide enough mass for the use of the projectiles of the present invention with these firearms.

The projectiles of the present invention can have a variety of configurations, including shot and bullets, but are preferably formed into bullets for use with firearms. The bullets can have noses of various profiles, including round nose, soft nose, or hollow point. 15 Either the bullet or the jacket, if so provided, can include a driving band which increases the accuracy of individual bullets and reduces the dispersion of multiple bullets.

The invention is further illustrated by the following specific examples, in which parts and percentages are by weight or volume, as indicated in the Tables. The examples show various projectiles of the present invention, fabricated according to the process described 20 herein. For each of the examples, the frangible projectiles can be made non frangible by heat treatment, for example, sintering. Furthermore, representative projectiles for each of the group of examples were fabricated into 9mm and .223 caliber bullets, fired and evaluated.

EXAMPLES 1-10

25 In Examples 1-10, frangible bullets are prepared from blends of high ductility metal powders, namely tin (Sn), and low ductility metal powders, namely iron (Fe), in the weight percentages indicated in Table I. The theoretical density of each blend is determined, and is also reported in Table I. In each Example, the blend has a theoretical density of less than lead. The high ductility metal powder has a particle size distribution of about 14% by 30 weight of particles of about 45 μm , about 48% by weight of particles having a particle size of about 75 μm , about 28% by weight of particles having a particle size of about 105 μm , about 7% by weight of particles having a particle size of about 150 μm , and about 3% by

weight of particles having a particle size of about 180 μm . The low ductility metal powder has a particle size distribution of about 22% by weight of particles up to about 44 μm , about 68% by weight of particles having a particle size of about from 44 to 149 μm , and about 10% by weight of particles having a particle size of about from 149 to 250 μm .

5 The powders are intimately blended with 0.15 weight percent zinc stearate using apparatus conventionally used for the handling of metal powders. The blends are cold compacted at a pressure of 90,000 psi for 0.15 second on a rotary dial press. The bullets are jacketed with copper by electroplating. The bullets are then loaded into cartridges, tested and evaluated, and provide excellent performance characteristics.

10 EXAMPLES 11-63

In Examples 11-63, the general procedure of Examples 1-10 is repeated, using blends of zinc (Zn) and iron. The specific blends and their theoretical densities are reported in Tables II and III. The resulting bullets are loaded into cartridges and evaluated, and found to provide excellent performance characteristics.

15 EXAMPLES 64-107

In Examples 64-107, the general procedure of Example 1-10 is repeated, using blends of tin and iron. The specific blends and their theoretical densities are reported in Table IV. The resulting bullets are loaded into cartridges and evaluated, and found to provide excellent performance characteristics.

11
TABLE I

			Density		
	Element A	Sn	0.264		
	Element B	Fe	0.275		
Example	VolA/VolB	%Wt.A	%Wt.B	Wt A/ Wt B	Th Dens (lbm/in^3)
1	0.50	32.43%	67.57	0.480	0.2713
2	0.75	41.86%	58.14%	0.720	0.2703
3	1.00	48.98%	51.02%	0.960	0.2695
4	1.50	59.02%	40.98%	1.440	0.2684
5	2.00	65.75%	34.25%	1.920	0.2677
6	3.00	74.23%	25.77%	2.880	0.2668
7	4.00	79.34%	20.66%	3.840	0.2662
8	5.00	82.76%	17.24%	4.800	0.2658
9	6.00	85.21%	14.79%	5.760	0.2656
10	1.94	65.06%	34.94%	1.862	0.2677

TABLE II

			Density		
	Element A	Zn	0.259		
	Element B	Fe	0.275		
Example	VolA/VolB	%Wt.A	%Wt.B	Wt A/ Wt B	Th Dens (lbm/in^3)
11	0.50	32.01%	67.99%	0.471	0.2697
12	0.75	41.40%	58.60%	0.706	0.2681
13	1.00	48.50%	51.50%	0.942	0.2670
14	1.50	58.55%	41.45%	1.413	0.2654
15	2.00	65.32%	34.68%	1.884	0.2643
16	3.00	73.86%	26.14%	2.825	0.2630
17	4.00	79.02%	20.98%	3.767	0.2622
18	5.00	82.48%	17.52%	4.709	0.2617
19	6.00	84.96%	15.04%	5.651	0.2613
20	1.94	64.63%	35.37%	1.827	0.2644

TABLE III

Example	Zinc-Iron Mix					
	% Wt Fe	% Wt Zn	Wt Zn/Wt Fe	Vol Zn/Vol Fe	Th Dens	95%th Dens
21	20.00%	80.00%	4.000	4.2472	0.262037	0.248935
22	22.00%	78.00%	3.545	3.7645	0.262346	0.249229
23	24.00%	76.00%	3.167	3.3623	0.262656	0.249523
24	26.00%	74.00%	2.846	3.0220	0.262966	0.249818
25	28.00%	72.00%	2.571	2.7303	0.263277	0.250114
26	30.00%	70.00%	2.333	2.4775	0.263589	0.250410
27	32.00%	68.00%	2.125	2.2563	0.263902	0.250707
28	34.00%	66.00%	1.941	2.0611	0.264215	0.251005
29	34.61%	65.39%	1.889	2.0061	0.264311	0.251096
30	34.62%	65.38%	1.889	2.0052	0.264313	0.251097
31	34.63%	65.37%	1.888	2.0043	0.264314	0.251099
32	34.64%	65.36%	1.887	2.0034	0.264316	0.251100
33	34.65%	65.35%	1.886	2.0025	0.264317	0.251102
34	34.66%	65.34%	1.885	2.0017	0.264319	0.251103
35	34.67%	65.33%	1.884	2.0008	0.264321	0.251104
36	34.68%	65.32%	1.884	1.9999	0.264322	0.251106
37	34.69%	65.31%	1.883	1.9990	0.264324	0.251107
38	34.70%	65.30%	1.882	1.9981	0.264325	0.251109
39	34.71%	65.29%	1.881	1.9972	0.264327	0.251110
40	35.00%	65.00%	1.857	1.9719	0.264372	0.251154
41	36.00%	64.00%	1.778	1.8876	0.264529	0.251303
42	38.00%	62.00%	1.632	1.7324	0.264844	0.251602
43	40.00%	60.00%	1.500	1.5927	0.265160	0.251902
44	42.00%	58.00%	1.381	1.4663	0.265476	0.252203
45	44.00%	56.00%	1.273	1.3514	0.265793	0.252504
46	46.00%	54.00%	1.174	1.2465	0.266111	0.252806
47	48.00%	52.00%	1.083	1.1503	0.266430	0.253108
48	50.00%	50.00%	1.000	1.0618	0.267749	0.253412
49	52.00%	48.00%	0.923	0.9801	0.267070	0.253716
50	54.00%	46.00%	0.852	0.9045	0.267390	0.254021
51	56.00%	44.00%	0.786	0.8343	0.267712	0.254327
52	58.00%	42.00%	0.724	0.7689	0.268035	0.254633
53	60.00%	40.00%	0.667	0.7079	0.268358	0.254940
54	62.00%	38.00%	0.613	0.6508	0.268682	0.255248
55	64.00%	36.00%	0.562	0.5973	0.269007	0.255557
56	66.00%	34.00%	0.515	0.5470	0.269332	0.255866
57	68.00%	32.00%	0.471	0.4997	0.269659	0.256176
58	70.00%	30.00%	0.429	0.4551	0.269986	0.256487
59	72.00%	28.00%	0.389	0.4129	0.270314	0.256798
60	74.00%	26.00%	0.351	0.3731	0.270643	0.257111
61	76.00%	24.00%	0.316	0.3353	0.270972	0.257424
62	78.00%	22.00%	0.282	0.2995	0.271303	0.257738
63	80.00%	20.00%	0.250	0.2654	0.271634	0.258052

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TABLE IV

Example	Tin-Iron Mix	% Wt Fe	% Wt Zn	Wt Zn/Wt Fe	Vol Zn/Vol Fe	Th Dens	95%th Dens
64	20.00%	80.00%	4.000	4.1710	0.265900	0.252605	
65	22.00%	78.00%	3.545	3.6970	0.266119	0.252814	
66	24.00%	76.00%	3.167	3.3020	0.266340	0.253023	
67	26.00%	74.00%	2.846	2.9678	0.266560	0.253232	
68	28.00%	72.00%	2.571	2.6813	0.266782	0.253442	
69	30.00%	70.00%	2.333	2.4331	0.267003	0.253653	
70	32.00%	68.00%	2.125	2.2158	0.267225	0.253864	
71	34.00%	66.00%	1.941	2.0241	0.267447	0.254075	
72	34.21%	65.79%	1.923	2.0053	0.267470	0.254097	
73	34.22%	65.78%	1.922	2.0044	0.267471	0.254098	
74	34.23%	65.77%	1.921	2.0035	0.267472	0.254099	
75	34.24%	65.76%	1.921	2.0026	0.267474	0.254100	
76	34.25%	65.75%	1.920	2.0018	0.267475	0.254101	
77	34.26%	65.74%	1.919	2.0009	0.267476	0.254102	
78	34.27%	65.73%	1.918	2.0000	0.267477	0.254103	
79	34.28%	65.72%	1.917	1.9991	0.267478	0.254104	
80	34.29%	65.71%	1.916	1.9982	0.267479	0.254105	
81	34.30%	65.70%	1.915	1.9973	0.267480	0.254106	
82	34.31%	65.69%	1.915	1.9964	0.267481	0.254107	
83	35.00%	65.00%	1.857	1.9365	0.267558	0.254180	
84	36.00%	64.00%	1.778	1.8538	0.267669	0.254286	
85	38.00%	62.00%	1.632	1.7013	0.267892	0.254498	
86	40.00%	60.00%	1.500	1.5641	0.268116	0.254922	
87	42.00%	58.00%	1.381	1.4400	0.268339	0.254922	
88	44.00%	56.00%	1.273	1.3271	0.268563	0.255135	
89	46.00%	54.00%	1.174	1.2241	0.268788	0.255348	
90	48.00%	52.00%	1.083	1.1296	0.269012	0.255562	
91	50.00%	50.00%	1.000	1.0427	0.269238	0.255776	
92	52.00%	48.00%	0.923	0.9625	0.269463	0.255990	
93	54.00%	46.00%	0.852	0.8883	0.269689	0.256205	
94	56.00%	44.00%	0.786	0.8193	0.269915	0.256419	
95	58.00%	42.00%	0.724	0.7551	0.270142	0.256635	
96	60.00%	40.00%	0.667	0.6952	0.270369	0.256850	
97	62.00%	38.00%	0.613	0.6391	0.270596	0.257067	
98	64.00%	36.00%	0.562	0.5865	0.270824	0.257283	
99	66.00%	34.00%	0.515	0.5372	0.271510	0.257500	
100	68.00%	32.00%	0.471	0.4907	0.271281	0.257717	
101	70.00%	30.00%	0.429	0.4469	0.271510	0.257934	
102	72.00%	28.00%	0.389	0.4055	0.271739	0.258152	
103	74.00%	26.00%	0.351	0.3664	0.271969	0.258370	
104	76.00%	24.00%	0.316	0.3293	0.272199	0.258589	
105	78.00%	22.00%	0.282	0.2941	0.272430	0.258808	
106	80.00%	20.00%	0.250	0.2607	0.272660	0.259027	

I CLAIM:

1. A lead free projectile comprising a compacted admixture of iron powder and at least one powder selected from tin, zinc and alloys and mixtures thereof.

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2. A projectile of Claim 1 wherein the iron powder consists essentially of particles of about from 44 to 250 microns.

3. A projectile of Claim 1 wherein the at least one powder selected from tin, 10 zinc and alloys and mixtures thereof consists essentially of particles of about from 45 to 180 microns.

4. A projectile of Claim 1 wherein the iron powder and the at least one powder selected from tin, zinc and alloys and mixtures thereof consist essentially of 15 particles of about from 44 to 250 microns.

5. A projectile of Claim 1 wherein the volume ratio of the at least one powder selected from tin, zinc and alloys and mixtures thereof to the iron powder is about from 0.5 to 6.

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6. A projectile of Claim 1 wherein the at least one powder is tin, the volume ratio of tin to iron is about 0.5, and the projectile has a theoretical density of about 0.2713 lbm/cubic inch.

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7. A frangible projectile of Claim 1.

8. A sintered projectile of Claim 1.

9. An unsintered projectile of Claim 1.

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10. A projectile of Claim 1 having a theoretical density of about from 0.26 to 0.28 lbm/cubic inch.

11. A lead free projectile comprising a compacted admixture of at least one high ductility metal powder and a low ductility metal powder, wherein the projectile has a density of less than about 80% of the theoretical density of lead.

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12. A lead free projectile of Claim 11 having a density of less than about 70% of the theoretical density of lead.

13. A lead free composite projectile comprising a compacted admixture of a
10 high ductility metal powder and a low ductility metal powder, wherein the low ductility
metal powder is less dense than lead and the projectile is less dense than lead.

14. A lead free projectile of Claim 13 wherein the high ductility metal powder is less dense than lead.

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15. A lead free projectile of Claim 14 having a density of about from 0.26 to 0.28 lbm/cubic inch.

16. A lead free projectile of Claim 15 having a density of about from 0.262 to 0.272 lbm/cubic inch.

17. A lead free projectile of Claim 13 wherein the volume ratio of high ductility metal powder to low ductility metal powder is about from 0.4 to 6.

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18. A lead free projectile of Claim 13 wherein the admixture comprises a volumetric mix ratio of about two parts high ductility metal to one part low ductility metal.

19. A lead free projectile of Claim 13 wherein the low ductility metal is at least one selected from the group consisting of iron, iron alloys and stainless steel

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20. A lead free projectile of Claim 19 wherein the high ductility metal is at least one selected from the group consisting of tin, zinc, alloys of tin, alloys of zinc, and mixtures thereof.

5 21. A lead free projectile of Claim 20 wherein the high ductility metal consists essentially of tin.

22. A lead free projectile of Claim 20 wherein the high ductility metal consists essentially of zinc.

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23. A lead free projectile of 20 wherein the high ductility metal consists essentially of at least one tin alloy.

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24. A lead free projectile of Claim 20 wherein the high ductility metal consists essentially of at least one zinc alloy.

25. A lead free projectile of Claim 20 wherein the high ductility metal consists essentially of a mixture of tin and zinc.

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26. A lead free projectile of Claim 20 wherein the high ductility metal consists essentially of a mixture of at least one tin alloy and zinc.

27. A lead free projectile of Claim 20 wherein the high ductility metal consists essentially of a mixture of tin and at least one zinc alloy.

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28. A lead free projectile of Claim 20 wherein the high ductility metal consists essentially of a mixture of at least one tin alloy and at least one zinc alloy.

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29. A lead free projectile of Claim 20 wherein the low ductility metal powder is at least one selected from the group consisting of iron, iron alloys and stainless steel.

30. A lead free projectile comprising a compacted admixture of a high ductility metal powder and a low ductility metal powder, wherein the high and low ductility powders are within a density ratio or range of about 0.260 - 0.280 lbm/cubic inch.

5 31. A lead free projectile comprising a compacted admixture of a high ductility metal powder and a low ductility metal powder, wherein the high and low ductility powders are within a density ratio or range of about +/- 10% of the apparent density of iron powder.

10 32. A lead free projectile of Claim 31 wherein the density of the high ductility metal powder is about from 10% greater than the density of wrought iron to 10% less than the density of wrought iron.

33. A lead free projectile having a density less than the theoretical density of

15 lead.

34. A cold compacted projectile of Claim 33.

ABSTRACT OF THE DISCLOSURE

Lead free projectiles having a density less than lead, including preferred
5 embodiments comprising a low ductility metal powder and a high ductility metal powder.

**DECLARATION and
POWER OF ATTORNEY**

RA-0336

As a below-named inventor, I declare that I believe that I am the original, first and sole inventor (if only one name is listed below) or an original, first and joint inventor (if plural names are listed below) of the subject matter which is claimed in the specification identified below and for which a patent is sought on the invention as titled therein. I hereby state that I have reviewed and understand the contents of said specification including the claims, as amended by any amendment referred to herein. I acknowledge the duty to disclose to the Office all information known to me to be material to patentability as defined in 37 CFR §1.56.

Full Name of Inventor ⁽¹⁾	Last Name STONE	First Name JEFFREY	Middle Name W.
Residence & Citizenship	City ELIZABETHTOWN	State or Foreign Country KENTUCKY	Country of Citizenship USA
Post Office Address	Post Office Address 239 OAKWOOD DRIVE	City ELIZABETHTOWN	State or Country KENTUCKY
			Zip Code 42701

Title of the Invention:**LEAD FREE POWDERED METAL PROJECTILES**

X Patent specification attached.

Patent specification was filed on _____ as U.S. application Serial No. _____
and was amended on _____ (if applicable).

No earlier-filed foreign applications of which priority benefit is claimed.

X Required information as to earlier-filed foreign applications of which priority benefit is claimed appears on page 2 attached.

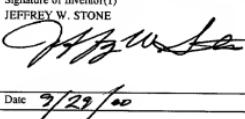
No earlier-filed U.S. applications of which priority benefit is claimed.

X Required information as to earlier-filed U.S. applications of which priority benefit is claimed appears on page 2 attached.

POWER OF ATTORNEY: The power to prosecute this application and transact all business in the Patent and Trademark Office connected therewith is hereby granted to the following X attorney(s) agent(s):

Name: Donald W. Huntley	Registration No.: 24,673
Send correspondence and direct telephone calls to:	Donald W. Huntley Huntley & Associates 1105 North Market Street PO Box 948 Wilmington, DE 19899-0948
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I further declare that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under Section 1001 of Title 18 of the United States Code, and that such willful false statements may jeopardize the validity of the application or any patent issuing thereon.

Signature of Inventor ⁽¹⁾ JEFFREY W. STONE 		
Date 3/29/00		

DECLARATION AND POWER OF ATTORNEY --- Page 2

Attorney's
Docket No. RA-0336

Required information as to earlier-filed foreign applications of which priority benefit is claimed.

I hereby claim foreign priority benefits under Title 35, United States Code, §119 of any foreign application(s) for patent or inventor's certificate listed below and have also identified below any foreign application for patent or inventor's certificate having a filing date before that of the application on which priority is claimed.

Country	Application No.	Filing Date	Priority Claimed (Yes-No)
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Required information as to earlier filed U.S. applications of which priority benefit is claimed.

I hereby claim the benefit under Title 35, United States Code, §120 of any United States application(s) listed below and insofar as the subject matter of each of the claims of this application is not disclosed in the prior United States application in the manner provided by the first paragraph of Title 35, United States Code, §112. I acknowledge the duty to disclose to the Office all information known to me to be material to patentability as defined in 37 CFR §1.56, which became available between the filing date of the prior application and the national or PCT international filing date of this application.

U.S. Application Serial No.	U.S. Filing Date	Status (patented, pending or abandoned)
09/226,252	JANUARY 7, 1999	PENDING
08/908,880	AUGUST 8, 1997	PATENTED